

AMERIARC

Ameri 2209 (Duplex)

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 2209-17

EN 1600: E 22 9 3 N L R 32

DESCRIPTION & APPLICATION:

Ameri 2209 is the universal "Duplex" electrode for welding & cladding of austenitic/ferritic microstructure stainless. The austenitic weld metal has a ferrite content of 40 to 50 % and especially LS-resistant to pitting corrosion and stress corrosion cracking.

A wide usage in chemical, petrochemical pulp & paper industries.

WELD METAL CHEMICAL ANALYSIS (TYPICAL WEIGHT %):

Mo	Ni	C	Si	P	Mn	S	Cr	Cu	Fe	N
3.0	9.0	.028	.90	.02	.90	.01	22.5	.02	bal	.18

Flux Color : Grey/tan

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	115,000 PSI (800 MPa)
Yield Strength	94,000 PSI (650 MPa)
Elongation	25%

WELDING CURRENT & INSTRUCTIONS:

Recommended Current : AC/DC(+)

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	55	70	90
Maximum Amperage	80	100	150

PACKAGING & DIMENSIONS:

Dimensions	Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
	Length (mm)	12" (300)	14" (350)	14" (350)
Packaging	Electrodes / lb	8.8	8.8	8.8
	Electrodes / kg	4.0	4.0	4.0